



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200
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D2499**Job Sheet 214744****Part No:** D2499**Job Qty:** 4 pcs**Part Name:** Mounting Bracket**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 10/30/20**Job Tracking No:****Due Date:** 11/9/20**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV C IPP A 00.06.26 Removed P/O for powder coat EC IPP C Rev C dwg 07-09-25 DD verified by EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs		11/7/20	0.00	0.27	Bandsaw - 1		<i>[Signature]</i>
110	HAAS 4 Axis - B4B	4 pcs		11/7/20	1.00	2.00	HAAS - 1 - B4B		<i>[Signature]</i>
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	4 pcs		11/7/20	0.00	0.00	QC 2 - 1		<i>[Signature]</i>
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



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Container No: S312605**Part:** D2499**Job No:** 214744**Serial No/Batch:** S312605**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
130	QC 8	4	11/7/20	0.00 0.00	QC 8 - 12
		pcs			QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
140	Handfinish - 1-1 Chemical-B4B	4	11/7/20	0.00 0.64	Handfinish - 1 - 1 - B4B
		pcs			Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 -

DAS

33

20/11/13

9-89

				B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	DAS 47 NOV 20 2020
150	Powdercoat - 2 White Gl(S)- B4B	4 pcs	11/9/20	0.00 0.53	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
					Powdercoat - 5 - B4B
					Powdercoat - 6 - B4B
					Powdercoat - 7 - B4B
					Powdercoat - 8 - B4B
					Powdercoat - 9 - B4B
					Powdercoat - 10 - B4B
160	QC 3	4 pcs	11/9/20	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43
					QC 3 - 24
					QC 3 - 61
					QC 3 - 81
					QC 3 - 82
					QC 3 - 87
					QC 3 - 47
170	Packaging 3-1 - Stock - B4B	4 pcs	11/9/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B

DAS 47 NOV 20 2020 9-89

20-11-23 9-89

DAS 82 9-89

NOV 23 2020

DAS 28 9-89 NOV 23 2020

					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
180 QC 21 - SA	4 pcs	11/9/20	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	DAS
					QC 21 - SA - 9	21
					QC 21 - SA - 77	8-39
					QC 21 - SA - 28	

NOV 23 2020

Part Op 100 - (Bandsaw)Cut blanks: 8.500" x 4.000"
 Descriptions: 110 - (HAAS CNC vertical machine #1)Machine as per folio D2499
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) *****mask slot as per dwg*****
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location:_____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X04.000	6061-T6 Bar 1.00 X 4.00	1.6000 ft (.4 ea)	100-Bandsaw - 1	S094297

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.000X04.000	2	15	0

Part Specifications

Specifications could not be found.

Plex 10/30/20 2:09 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 214744
Description: Mount		Part Number: D2499
Inspection Dwg: D2499	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.585	+/-0.010	0.581	✓		Vern.	DTP-05
1.252	+/-0.010	1.247	✓		"	
2.085	+/-0.010	2.082	✓		"	
3.585	+/-0.010	3.582	✓		"	
3.960	+/-0.010	3.959	✓		"	
0.375	+/-0.010	0.372	✓		"	
0.875	+/-0.010	0.875	✓		Hght. G.	DTP-04
1.500	+/-0.010	1.497	✓		"	
3.525	+/-0.010	3.525	✓		"	
4.150	+/-0.010	4.148	✓		"	
5.200	+/-0.010	5.195	✓			
3.460	+/-0.010	3.460	✓		H.G.	31006
3.335	+/-0.010	3.335	✓		Vern	DTP-05
2.541	+/-0.010	2.541	✓		"	
0.25	+/-0.010	0.248	✓		"	
5.700	+/-0.010	5.698	✓		"	
0.115	+/-0.010	0.115	✓		"	
0.770	+/-0.010	0.770	✓		"	
1.000	+/-0.010	1.003	✓		"	
0.25	+/-0.010	0.248	✓		Vern	DTP-05
0.38	+/-0.010	0.376	✓		"	
0.250	+/-0.010	0.250	✓		"	
0.500	+/-0.010	0.501	✓		"	
R0.25	+/-0.010	0.250	✓		Rad. G.	REF
R0.50	+/-0.010	0.500	✓		"	
R0.38	+/-0.010	0.380	✓		"	
R0.13	+/-0.010	0.130	✓		"	
R0.25	+/-0.010	0.250	✓		"	
R0.06	+/-0.010	0.060	✓		"	
Ø0.257	+0.006/-0.001	0.258	✓		Vern.	DTP-05
Ø0.386	+0.006/-0.001	0.387	✓		"	

Measured by: DTP	Audited by: 33	Prototype Approval:	N/A
Date: 20-11-12	Date: 20/11/13	Date:	N/A
Rev	Date	Change	Revised by
A	08.04.11	New Issue	KJ/DD
			Approved

Entered: _____ Date: _____

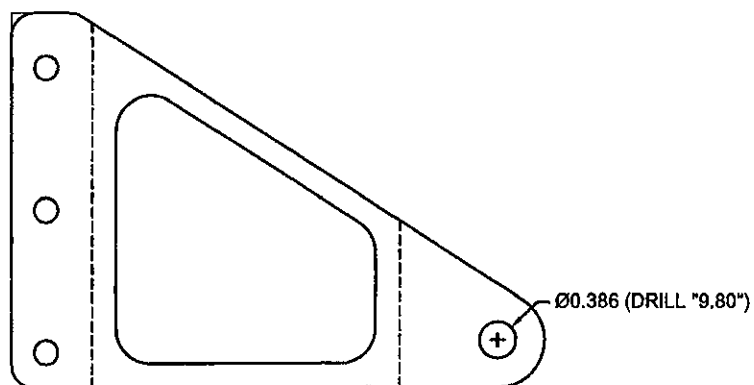
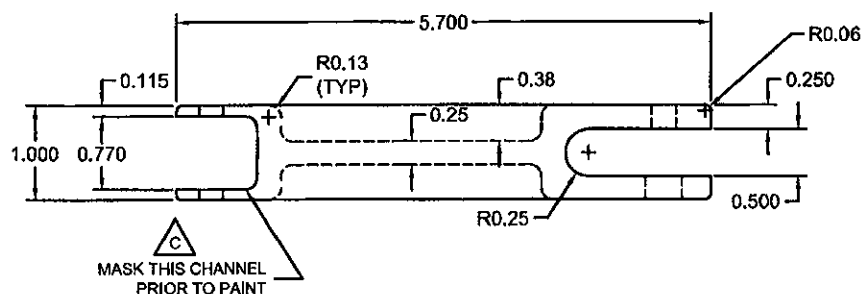
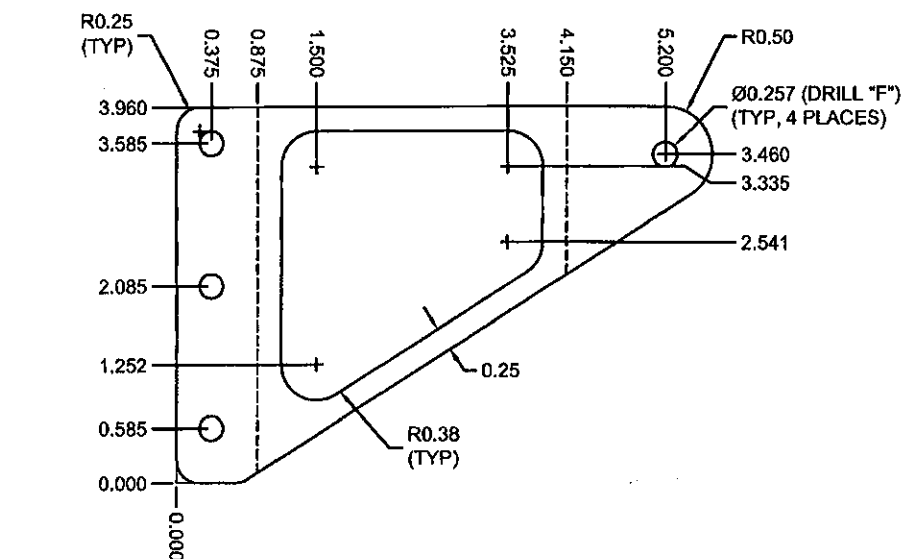


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



RELEASED

07.08.29

D2499 MOUNT

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2499" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.65 lbs

C	- ADDED MASKING DETAIL - DUE TO TIGHT FIT WHEN INSTALLED ON BASKET - ADD MASKING STEP TO ESTIMATE	DC	07.07.25
B	CHANGE HOLE DIA TO .386	KH	95.12.06
A	NEW ISSUE	BW	95.11.09
REV.	DESCRIPTION	BY	DATE
DESIGN	B WILLIAMS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>SC</i>		
CHECKED	<i>SC</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>SC</i>	D2499	SHEET 1 OF 1
APPROVED	<i>SC</i>	TITLE	SCALE
DE APPR.	<i>SC</i>	MOUNT	1:2
DATE	07.07.25	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	